

Work Order ID 74091

Page 1

Wednesday, September 21, 2011 1:22:07 PM

Item ID: D350-607-141

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Lid Opener Installation

Start Date: 9/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-09-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D350-607-141
CHG001

0.00

8/11/13

MLT 11-9-26
①

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

11/9/26 SL ①

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8/11/13

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74091

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Start Date: 9/21/2011 Start Qty: 1.00



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Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-141								
	Location: _____								
	PPP rev: <u>A</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SP 11-09-30
11/10/3

CMF 11-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 74091

Parent Item: D350-607-141

Parent Item Name: Automatic Lid Opener Installation

Start Date: 9/21/2011





Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.01.18 verified by:EC
545 DD 10.04.19 verified by:EC

IPP RevB: as
IPP Rev:C as per ecn10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-1  Gas Spring Bracket		Manufactured	No			110	Each	18.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST096		18							
				53760		18							
D3953-3  Gas Spring Stud, Lid		Manufactured	No			110	Each	12.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST096		12							
				71875		12							
D3953-5  Gas Spring Stud, Base		Manufactured	No			110	Each	14.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST096		14							
				71270		14							
D3953-7  Spring Spacer		Manufactured	No			110	Each	9.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST096		9							
				65053		4							
				71885		5							

B74168 11/9/30 \$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 74091

Parent Item: D350-607-141

Parent Item Name: Automatic Lid Opener Installation

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

110 Each

8.0000

4 4



Gas Spring Washer



B74169 11/9/2011

Location

Loc Qty

Loc Code

ST096

8

69025

4

71869

4

D3953-11

Manufactured No

110 Each

17.0000

2



Gas Spring Spacer



2

Location

Loc Qty

Loc Code

ST096

17

71268

17

D3953-13

Manufactured No

110 Each

15.0000

2



Gas Spring Spacer



2

Location

Loc Qty

Loc Code

ST096

15

52761

15

D3969-1

Manufactured No

110 Each

29.0000

2



Spring (Basket Lid)



11/9/2011

Location

Loc Qty

Loc Code

ST272

29

72364

9

73523

20

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 74091

Parent Item: D350-607-141

Parent Item Name: Automatic Lid Opener Installation

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C11A Purchased No
BOLT

110 Each 38.0000 4

Location Loc Qty Loc Code

ST357 38

118116 18

118838 20

AN3C16A Purchased No
Bolt

110 Each 66.0000 4

Location Loc Qty Loc Code

ST352 66

115835 1

118422 40

118628 25

AN310-4 Purchased No
NUT

110 Each 21.0000 4

Location Loc Qty Loc Code

ST324 21

118112 21

MS21043-3 Purchased No
Nut

110 Each 1,082.000 8

Location Loc Qty Loc Code

FG 72

103691 72

ST301 1010

118077 30

118614 500

118686 480

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 74091

Parent Item: D350-607-141

Parent Item Name: Automatic Lid Opener Installation

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-2-12

Purchased

No

110

Each

182.0000

4



COTTER PIN

Location

Loc Qty

Loc Code

ST308

179

118078

179

ST309

3

111499

3

NAS1149C0332R

Purchased

No

110

Each

4,099.000

8



Washer

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

4092

116304

55

117460

18

117887

169

118078

2

118179

78

118354

3770

NAS1149C0432R

Purchased

No

110

Each

4,234.000

4



Washer

Location

Loc Qty

Loc Code

ST297

4234

117291

4234

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1	D3953-3	GAS SPRING STUD (LID)
2	1	1	D3953-5	GAS SPRING STUD (BASE)
2	1	1	D3953-7	GAS SPRING SPACER
4	2	2	D3953-9	GAS SPRING WASHER
2	1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	1		D3953-15	GAS SPRING BRACKET
	1		D3953-17	GAS SPRING SPACER
2	1	1	D3969-1	GAS SPRING
4	2	2	AN3C11A	BOLT
	2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	2	2	AN310-4	CASTELLATED NUT
8	4	4	MS21043-3	NUT
4	2	2	MS24665-212	COTTER PIN
8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)